

FIG. 1

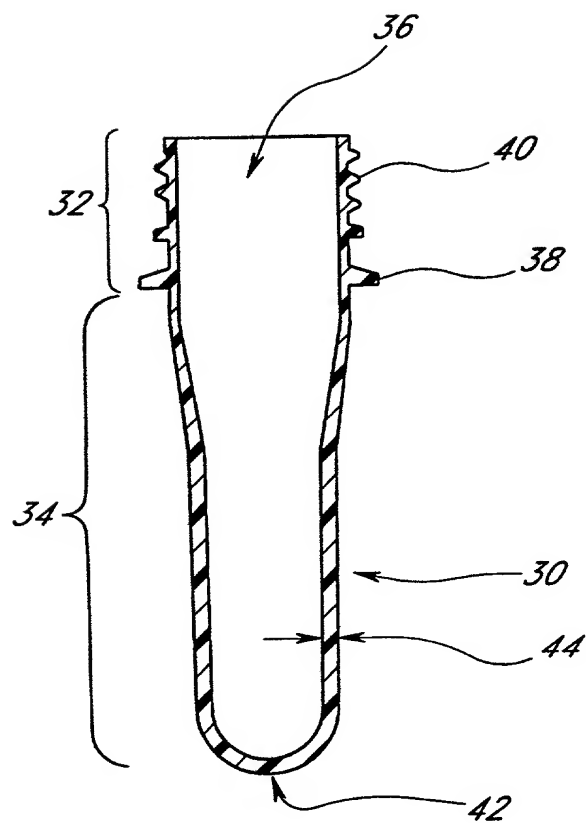


FIG.2

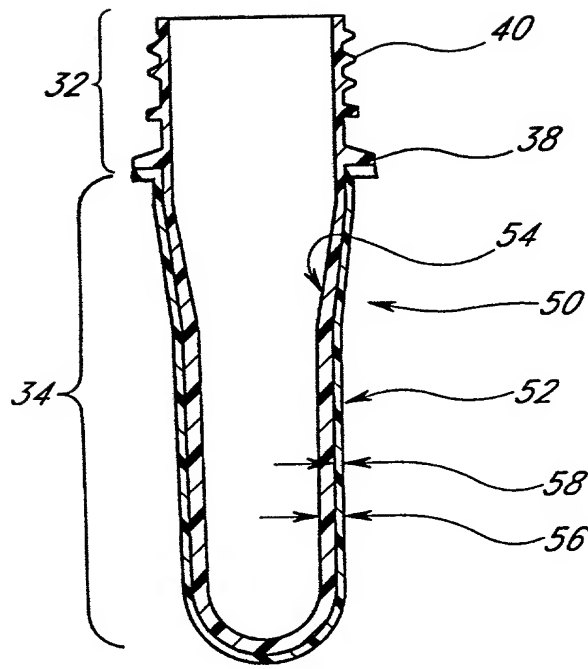


FIG.3

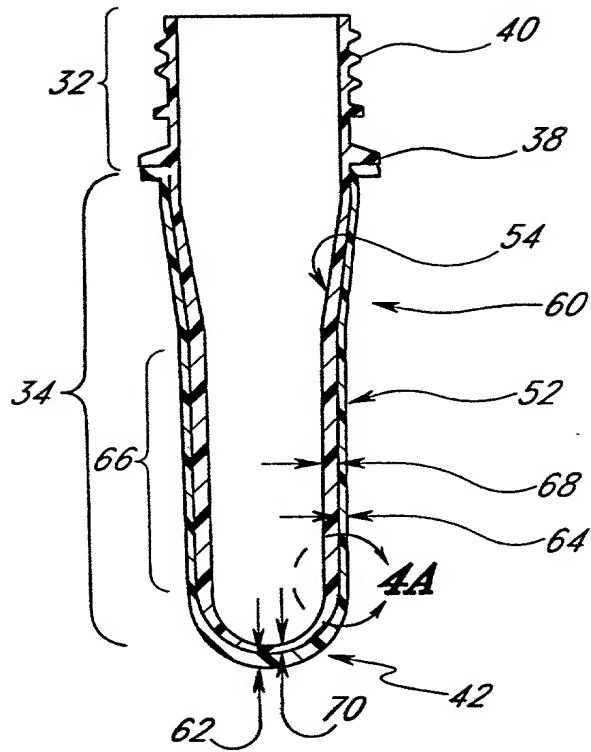


FIG. 4

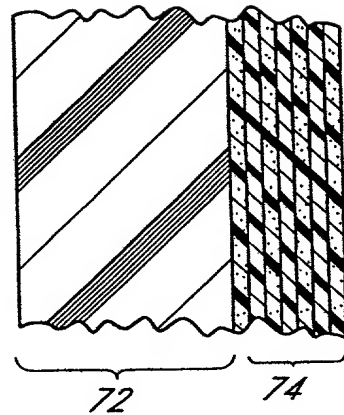


FIG. 4A

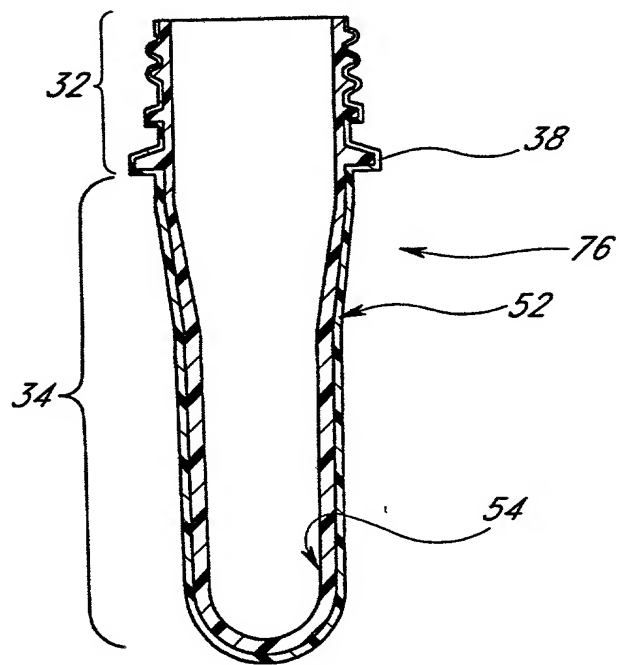


FIG.5

FIG. 1 is a schematic diagram of a container assembly. A bottle 50 is positioned within a rectangular frame 80. The frame has four circular fasteners at the corners. A U-shaped component 82 is located at the bottom of the frame, surrounding the base of the bottle.

FIG. 6

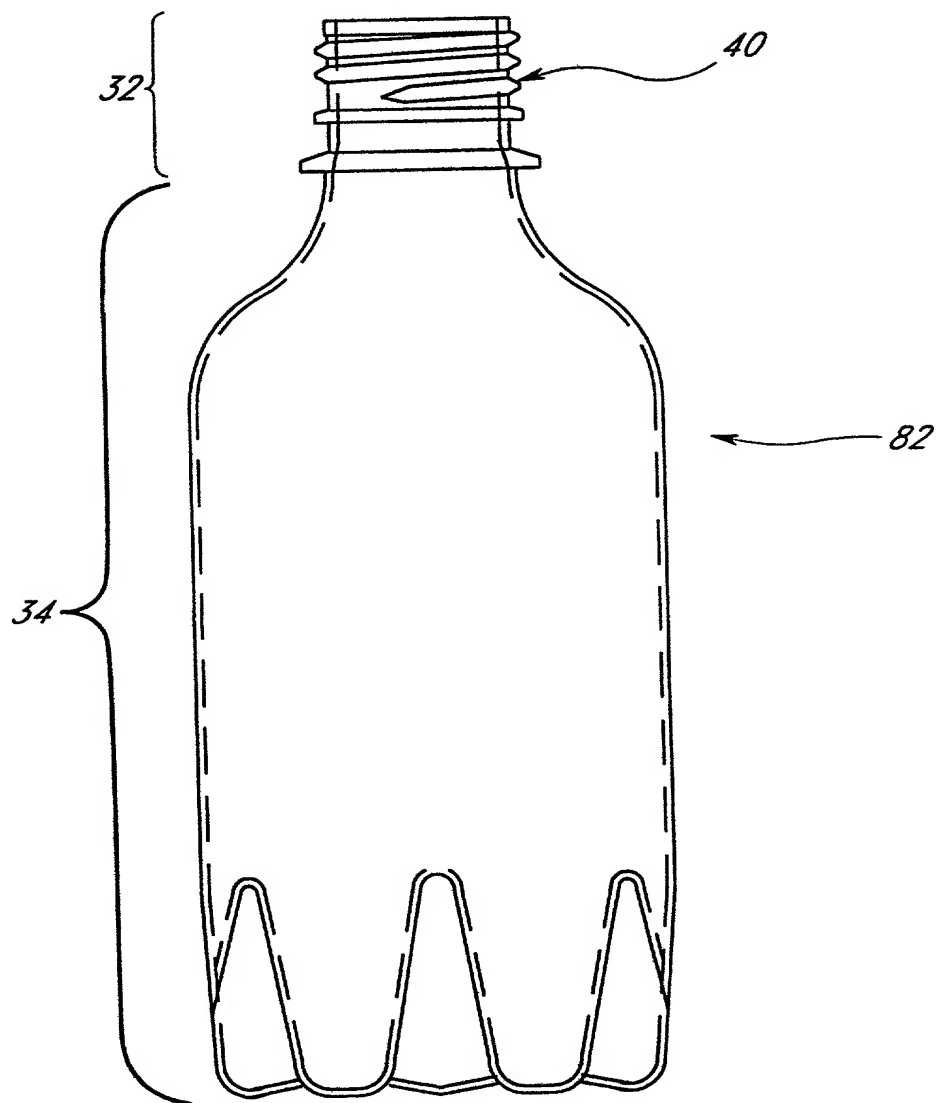


FIG. 7

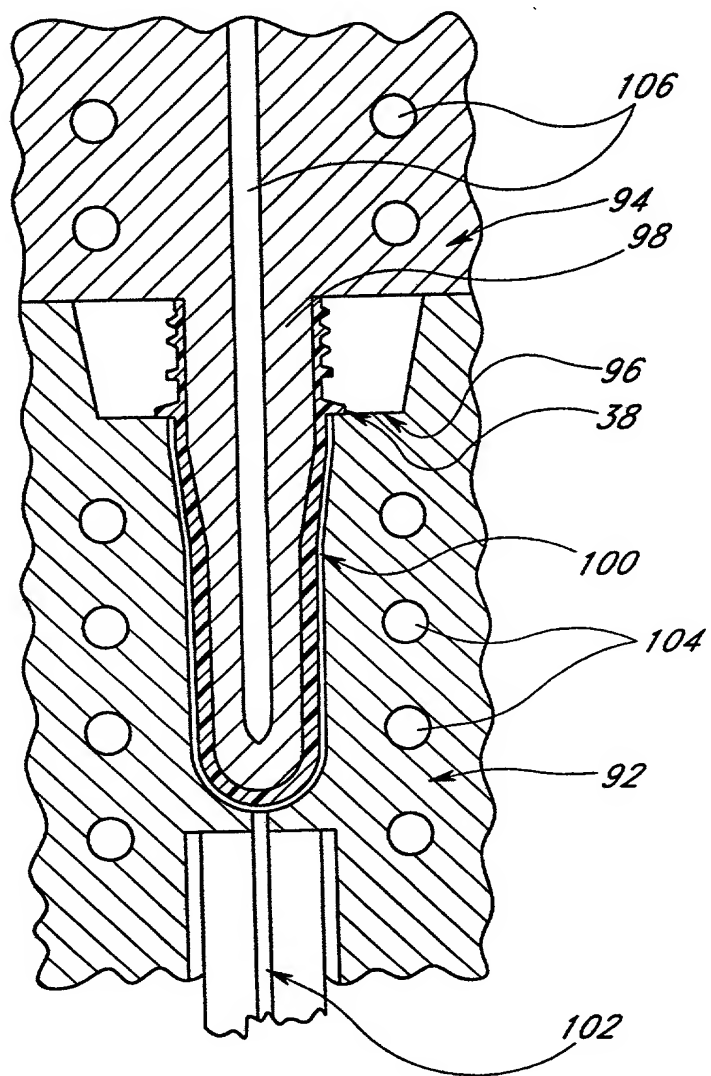


FIG. 9

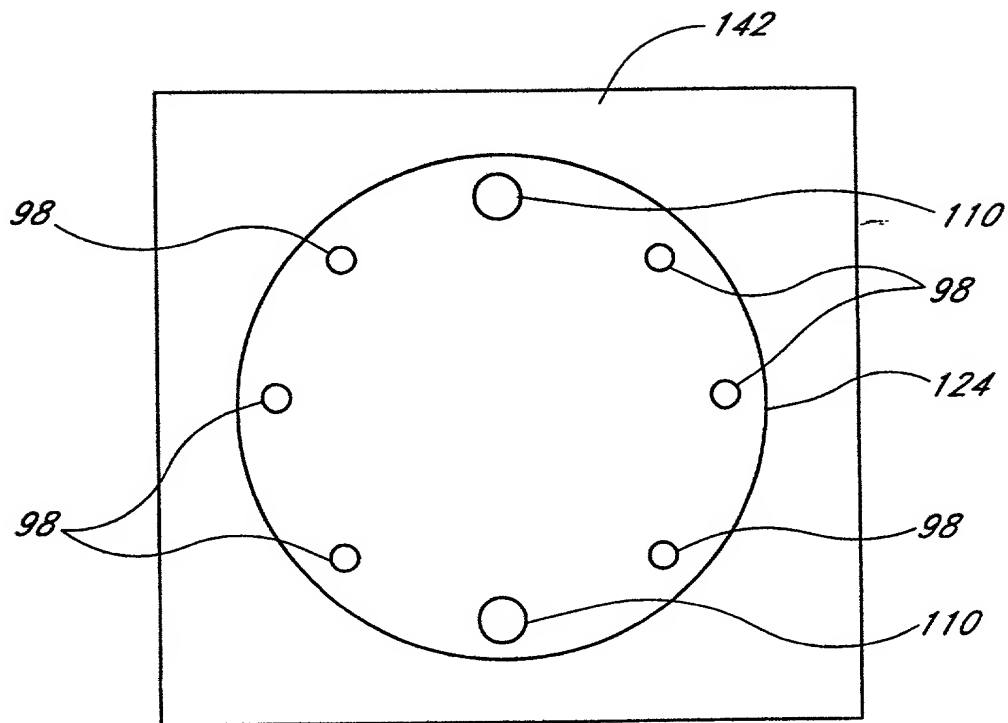


FIG. 10

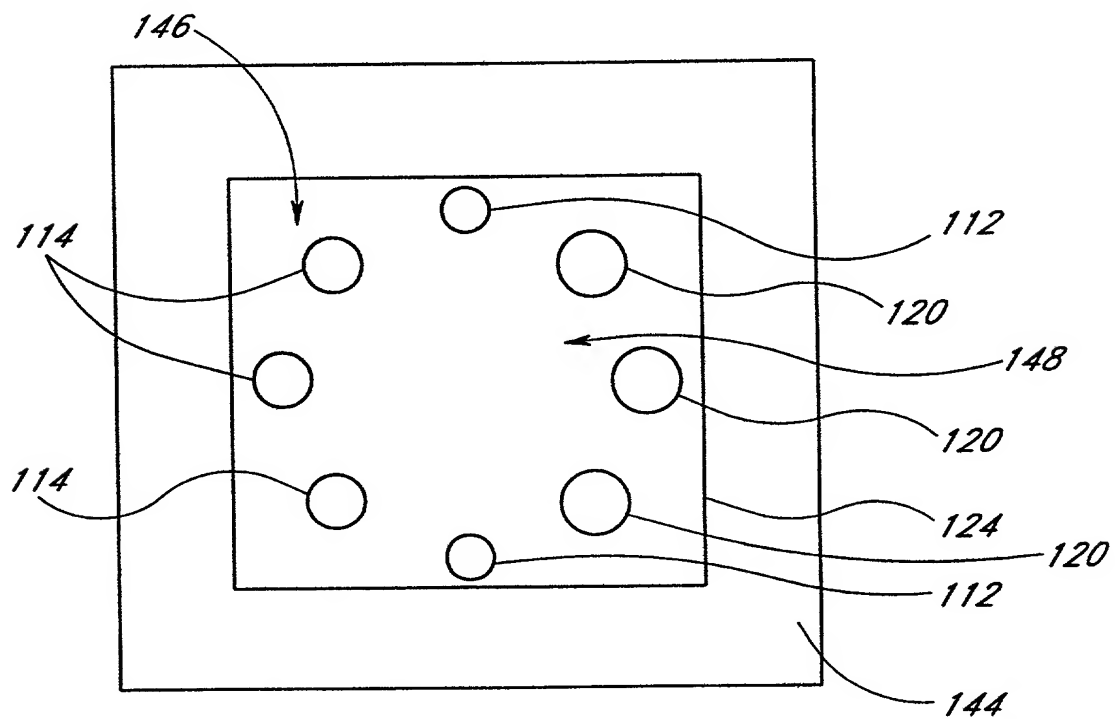


FIG. 11

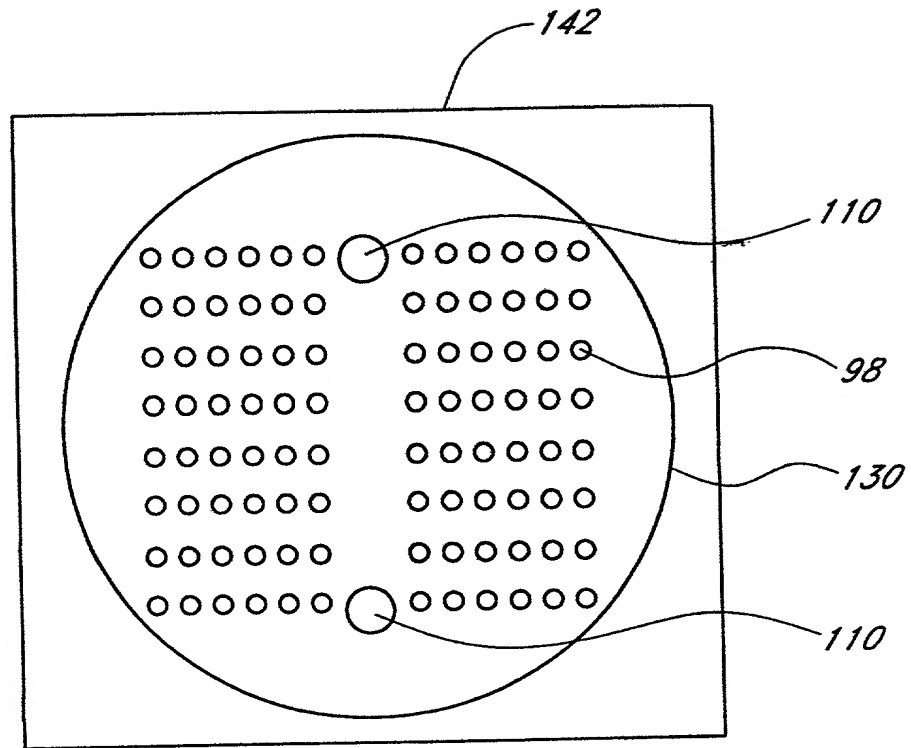


FIG. 12

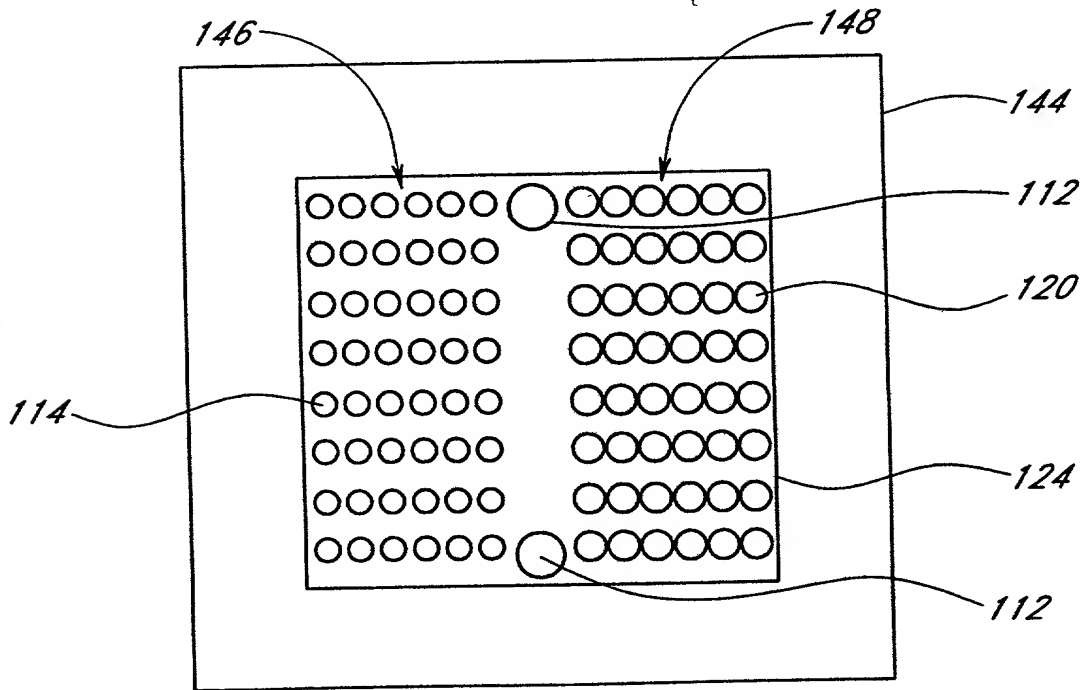


FIG. 13

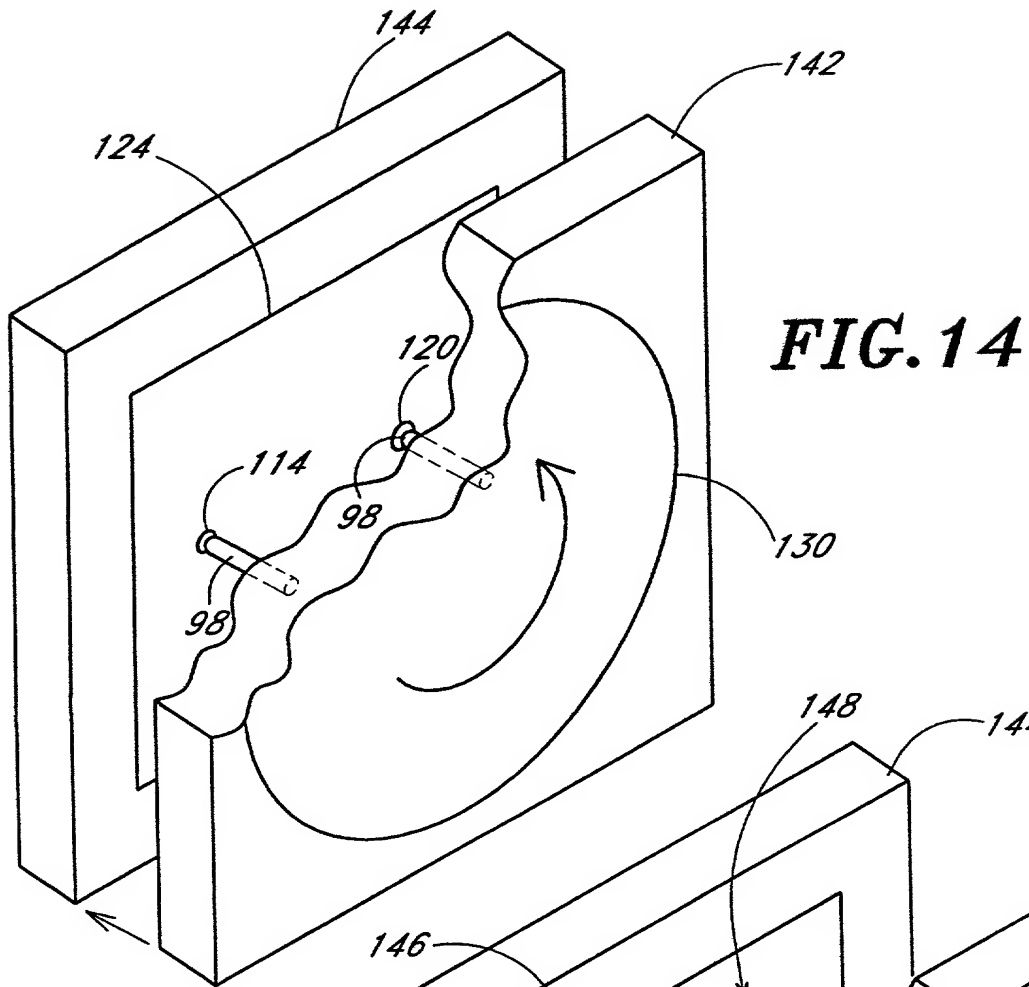
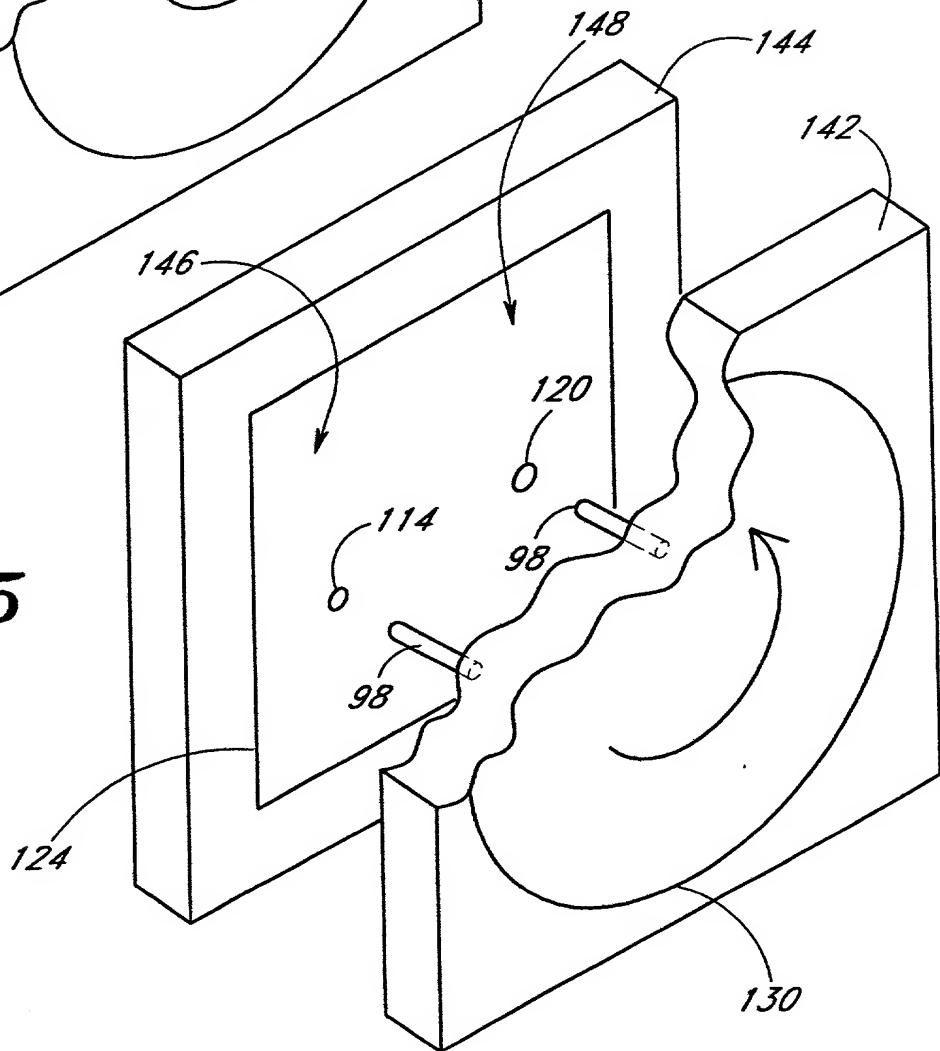


FIG. 15



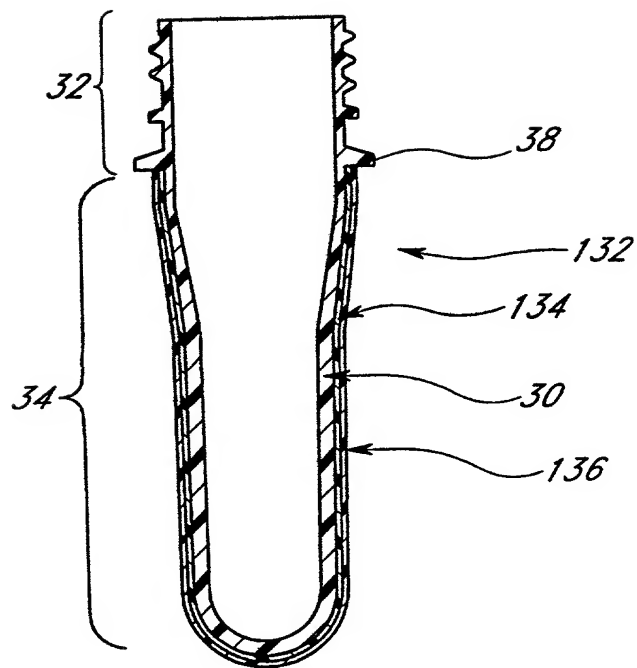


FIG. 16

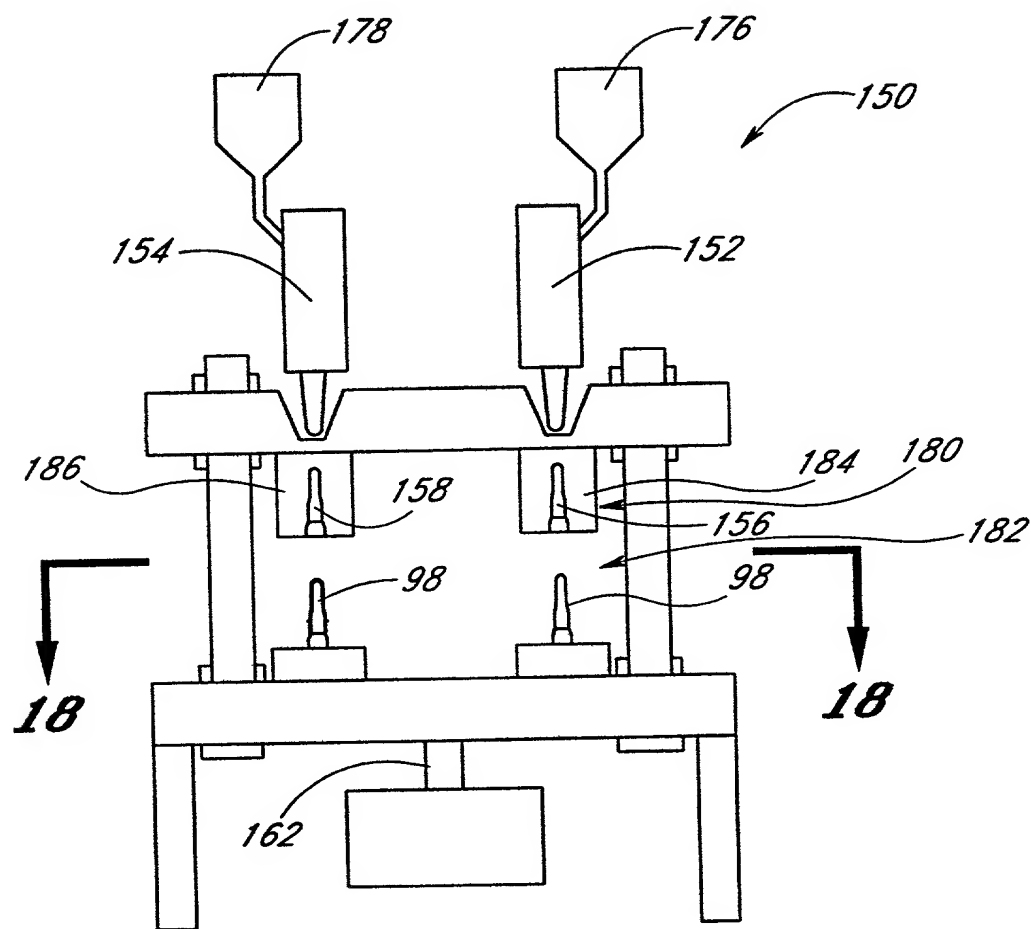


FIG. 17

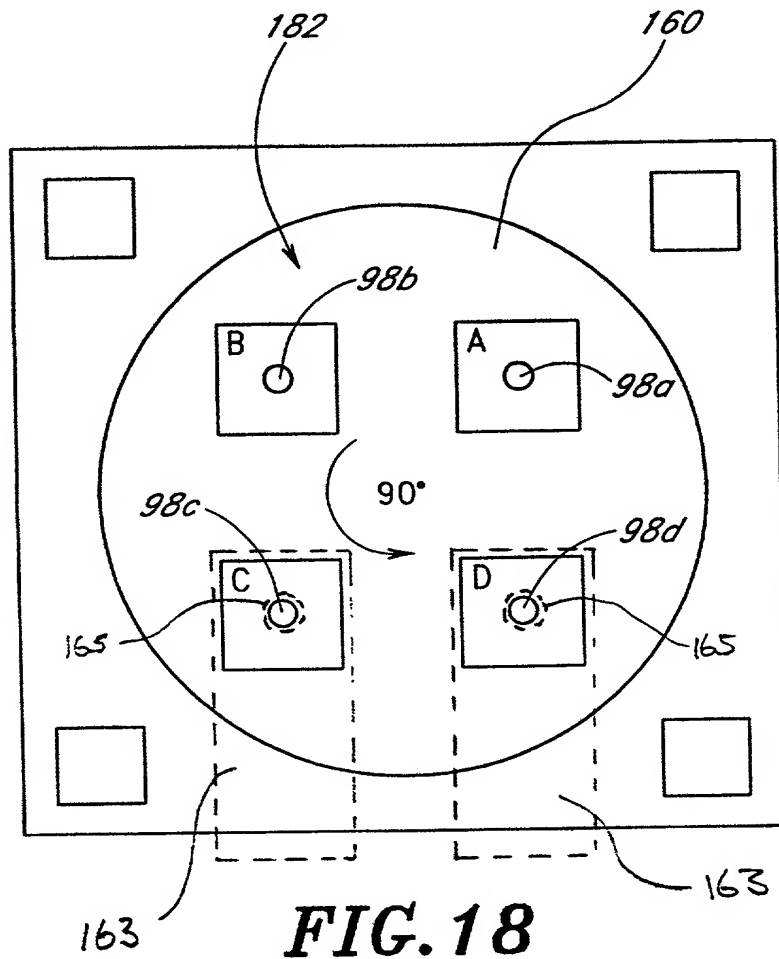
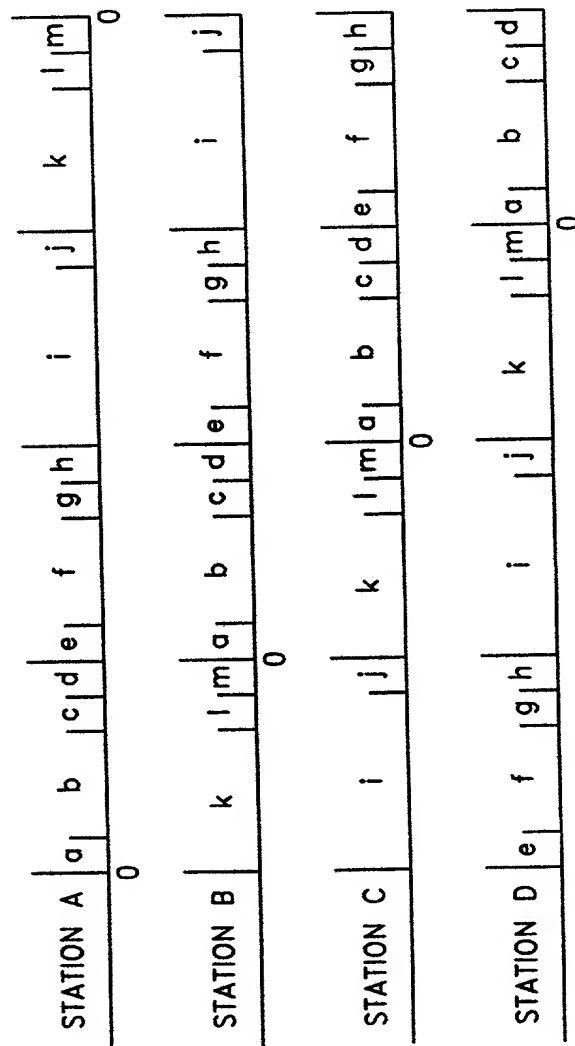


FIG. 18



STAGE	ACTIVITY
0	New Cycle start point
a	Insert mandrel into molding cavity
b	Inject and cool
c	Remove mandrel from cavity
d	Index 90°
e	Insert mandrel into coating cavity
f	Inject and cool
g	Remove mandrel from cavity
h	Index 90°
i	Preform cools on mandrel
j	Index 90°
k	Preform cools on mandrel
l	Eject preform
m	Index 90°

FIG. 19

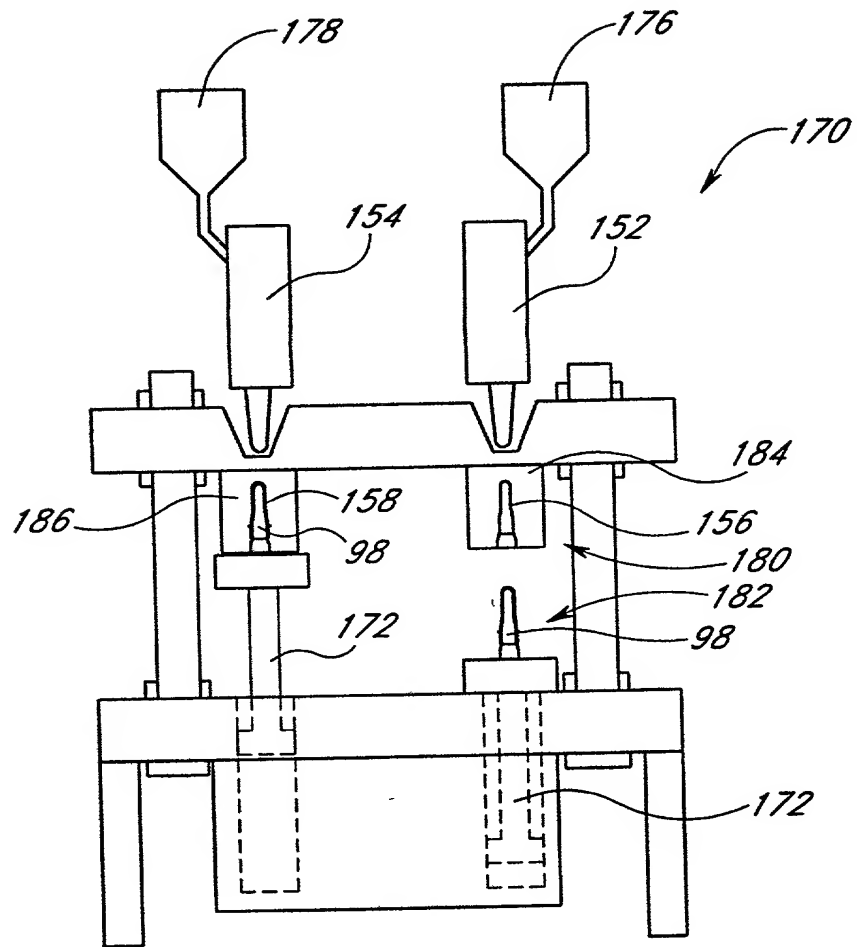


FIG. 20

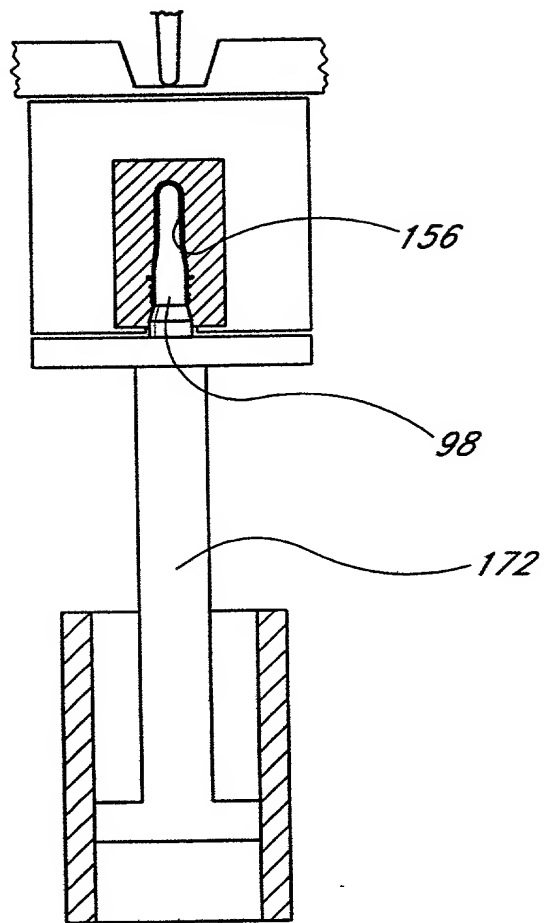


FIG.21

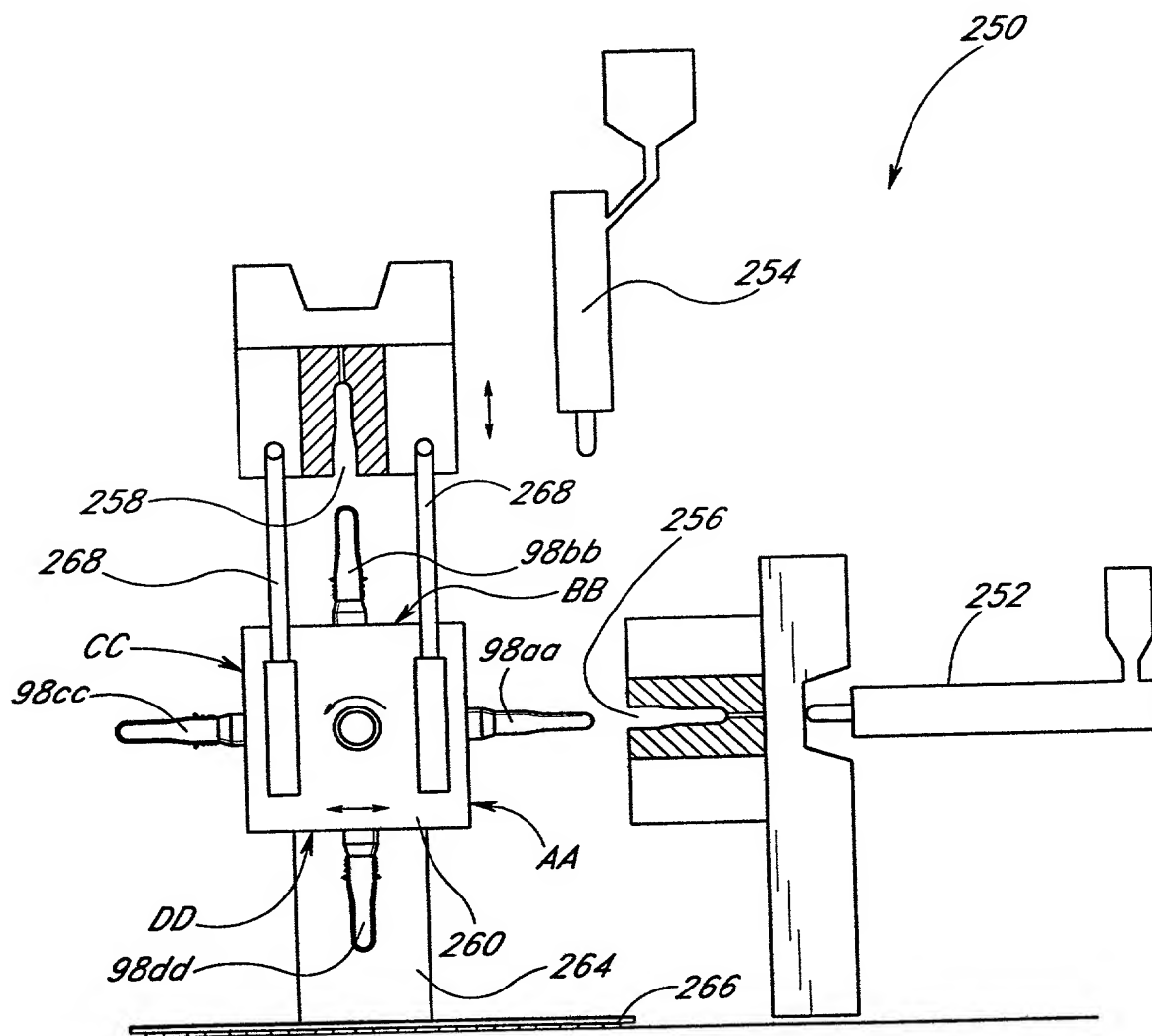


FIG. 22

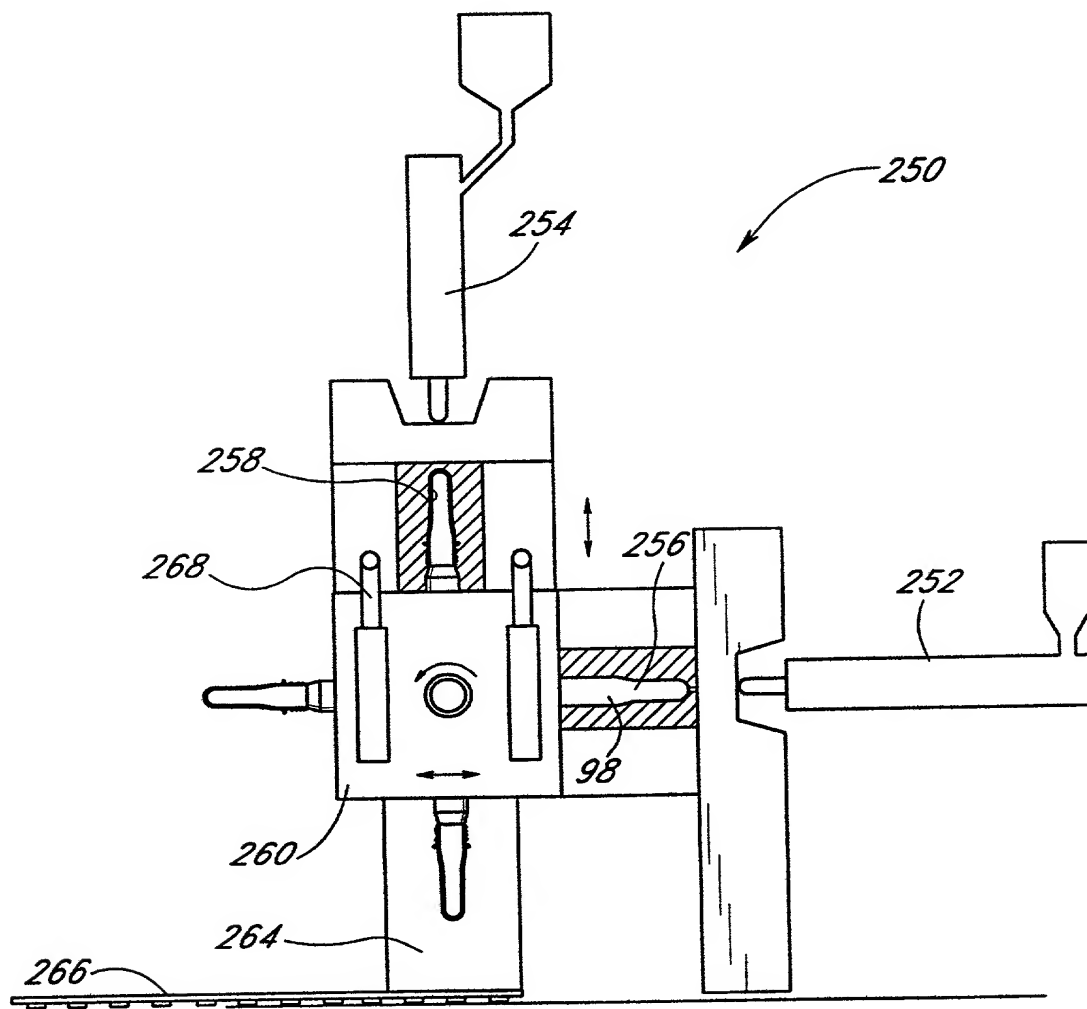
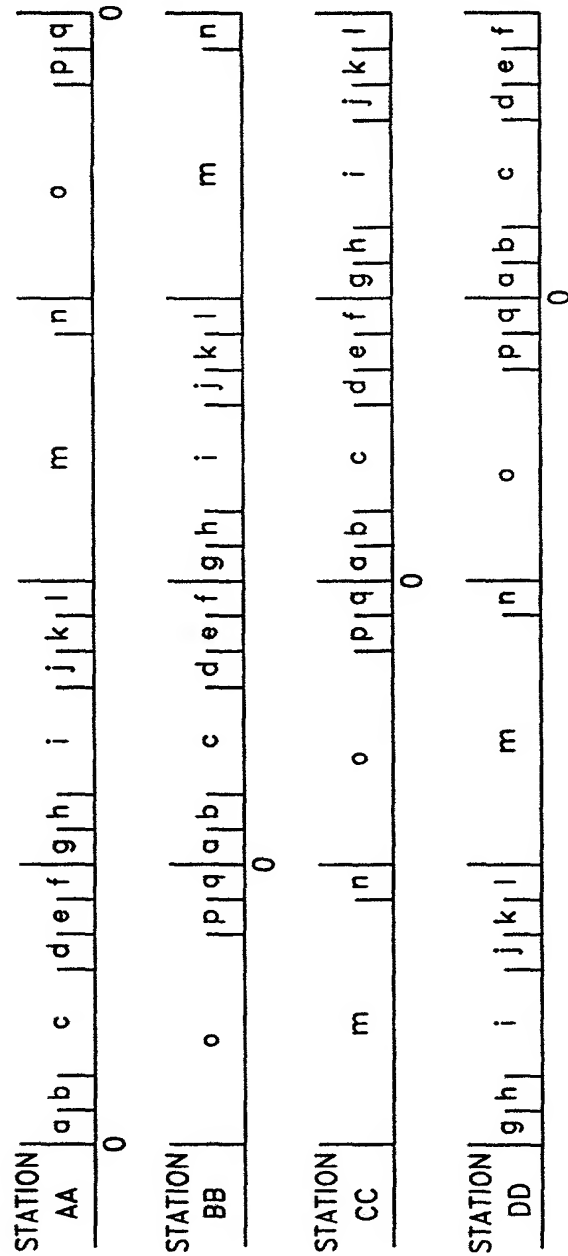


FIG.23



STAGE	ACTIVITY
0	New Cycle start point
a	Wait
b	Insert mandrel into mold cavity
c	Inject and cool
d	Open mold
e	Wait
f	Rotate turntable 90°
g	Insert mandrel into 2d mold cavity
h	Wait
i	Inject and cool
j	Wait
k	Open mold
l	Rotate 90°
m	Perform cools on mandrel
n	Rotate 90°
o	Perform, cools on mandrel
p	Eject Perform
q	Rotate 90°

FIG. 24

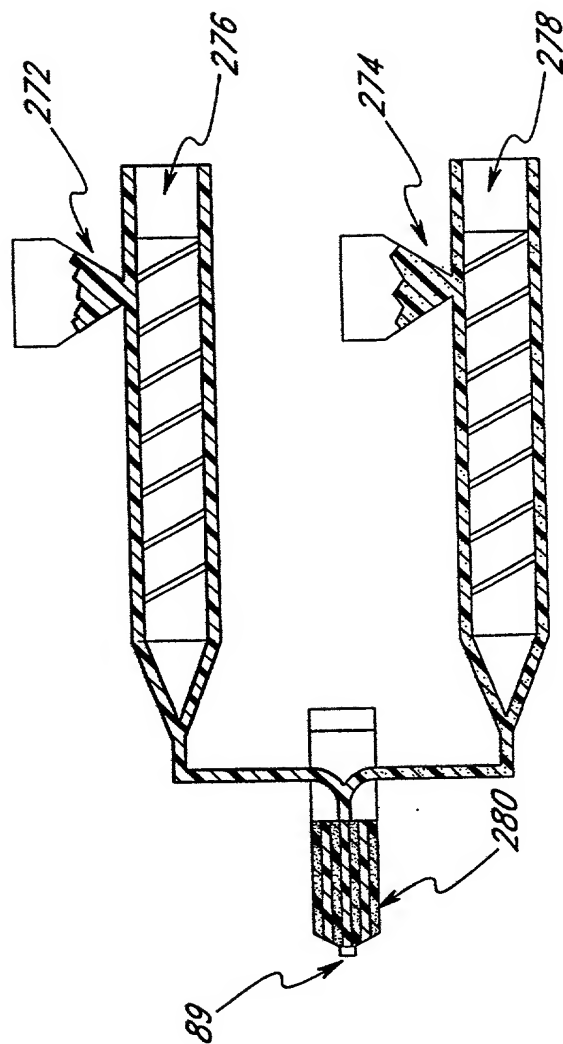


FIG.25

FIG. 26

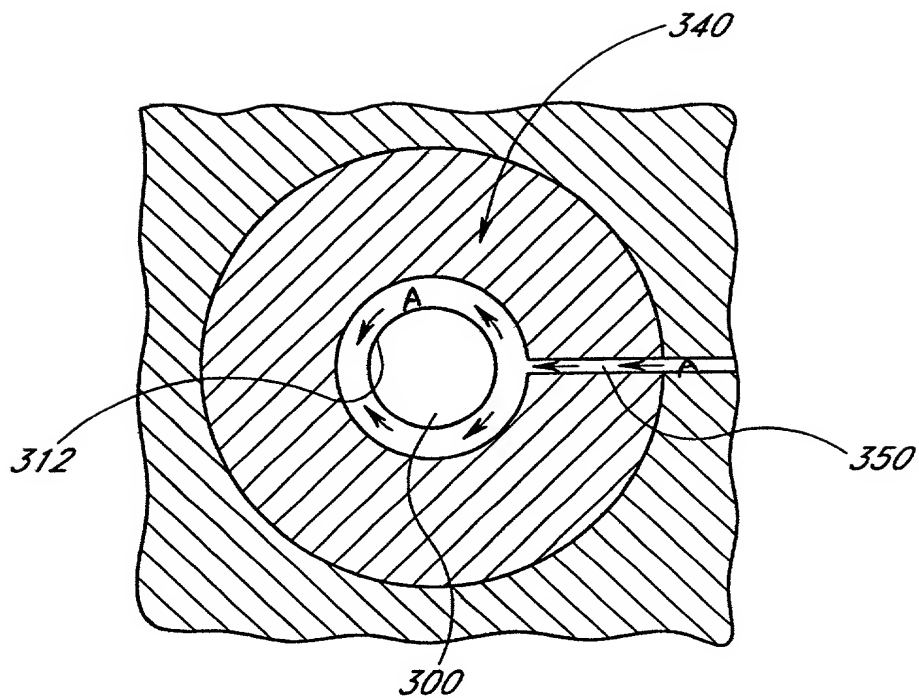


FIG. 27

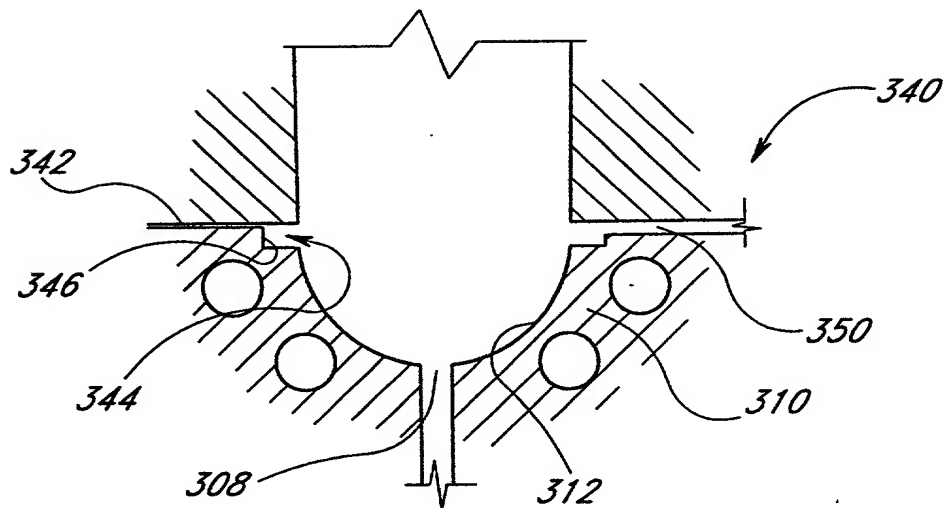


FIG. 28